

# Work Order ID 54718-1

December 17, 2009 8:21:18 AM

TODAY

Page 1

Item ID: D3480-3

Revision ID:

Item Name: Tube

Start Date: 12/17/2009 Start Qty: 4.00

Required Date: 12/17/2009 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: MF

Date: 09-12-17 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3480

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

Cut as per dwg D3480

B  
B

0.00

B 9-12-17

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

B 9-12-17

120

0.00



QC8- Inspect parts - second check

QC

Memo

Quality Control

0.00

>> 8091217

(X8)



# Work Order ID 54718

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Page 2

Item ID: D3480-3

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Required Date: 12/17/2009 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

1-Roll as per dwg D3480 2-Spot weld as per dwg D3480 3-Deburr SB 09/12/17 => M.L. 09/12/17

(4x)

140



QC

Quality Control

QC11- Inspect spot weld per QSI004

0.00

Memo

0.00

SB 09/12/17

(4x)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=> SB 09/12/17

(4x)



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Page 3

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: *GA*

0.00

Memo

0.00

*SS 09/12/17*

*e x*

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*09/12/17*  
*mf*  
*09-12-17*





# Picklist Print

December 17, 2009 8:21:18 AM

Work Order ID: 54718

Parent Item: D3480-3

Parent Item Name: Tube

Comments:

Component Item ID/  
Item Name

Replacement  
Item ID

Mfg/  
Purch

Bin  
Item

Primary  
Location

Last  
Location

Route  
Seq ID

Unit of  
Measure

Qty on  
Hand

Remaining  
Qty To Pick

Qty  
Issued

Date  
Issued

Status

M304S26GA



304/316 0.018 SHEET



Start Date: 12/17/2009

Start Qty: 4.00

Required Date: 12/17/2009

Required Qty: 4.00

Purchased

No

sf

171.0064

0.2401



B9-12-17

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

MAT

171.0063895

105591

0.39

107021

1.21

108415

3.19

109398

70.2163895

112885

96

109398





DART AEROSPACE LTD		Work Order:	5476
Description: Tube		Part Number:	D3480-3
Inspection Dwg: D3480 Rev: B		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

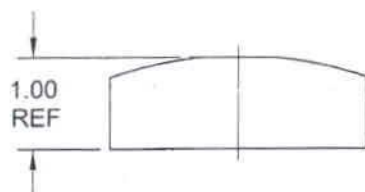
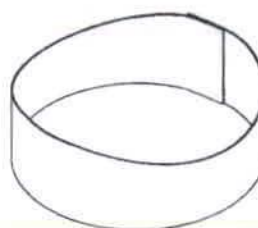
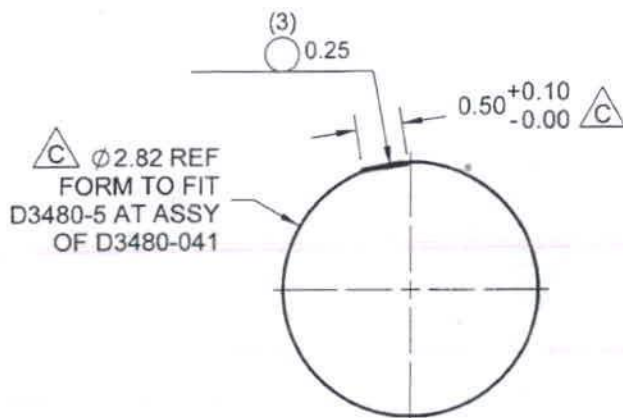
[illegible]



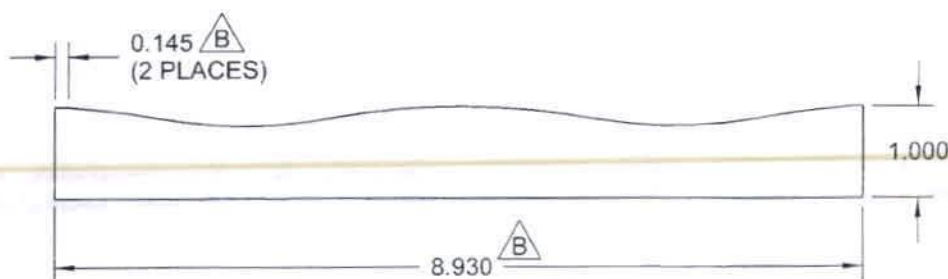


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 4 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

RELEASE  
09/01/30 *[Signature]*



### D3480-3 TUBE



### D3480-3F TUBE FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  $\triangle C$   
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**SPOT WELD TEST RECORD**  
**AMS-W-6858A**  
CLASS 'C'

**TEST NO#:** 72

**EMPLOYEE:** Mark Gregory

**PART NUMBER:** D3480-3

**JOB NUMBER:** B54715

**MATERIAL TYPE:** 304

**MATERIAL THICKNESS:** 0.011

**GROUP SPECIFICATION**

- |                                     |                               |
|-------------------------------------|-------------------------------|
| <input type="checkbox"/>            | Group 1: Aluminum & magnesium |
| <input type="checkbox"/>            | Group 2: Iron; nickel; cobalt |
| <input checked="" type="checkbox"/> | Group 3: Titanium <u>SS</u>   |

**TEST RESULTS**

	PASS	FAIL	
VISUAL:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]	
PENETRATION:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]	
PULL STRENGTH:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]	PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

**DATE OF TEST COUPON:** 09/12/17  
**QUALIFIER:** SS

